

Work Order ID 59810

Friday, June 11, 2010 10:46:11 AM



Page 1

Item ID: 41232-200-004-001

Accept



Setup Start



Revision ID:

Item Name: Reducer Tee Assembly

Stop



Start Date: 6/11/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 7-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

41232-200-004

Rev IR

100

0.00



CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

1-Turn AN815-4J as per Dwg 41232-200-004 2-Deburr as Required.

SA 10/06/21

Handwritten circled 8 and slash

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Drill as per Dwg 41232-200-00
2-SPOT FACE 5/8" TO LOCATE FITTING FOR WELDING
3-Deburr

SA 10/06/21 / SL 10/07/23
SA 10/06/21 / SL 10/07/23

Handwritten circled 8

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Required Date: 6/18/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jul 10 - 22

(4/8)

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg 41232-200-004 □A/R

SS Rod

Batch: *M109213*

Debur → *SAD*

10-07-26

(X8) Pl 10-07-24

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1-WELD INSPECTION □2-Pressure test as per Dwg 41232-200-004□3-
Passivate Finish.

10 10.07.27

TESTER IAW Dwg to 3000 PSI

Pickling Solution #001014

M115318

Passivating solution #049728

M115322

(Handwritten signatures)

10 07 27

10 08 05

10 08 05

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Page 3

Item ID: 41232-200-004-001

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Setup Start

Revision ID:

Stop

Item Name: Reducer Tee Assembly

Start Date: 6/11/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 364

0.00



Packaging

Memo

0.00

Packaging

10/8/06 6 sf 82

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/06 HJ
mf
10-8-06

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Picklist Print

Friday, June 11, 2010 10:46:16 AM

Page 1

Work Order ID: 59810

Parent Item: 41232-200-004-001

Parent Item Name: Reducer Tee Assembly


Comments: IPP Rev:A New Issue 07-03-01 JLM

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN815-4J  union		Purchased	No			100	Each	14.0000	1	10			

Location

Loc Qty

Loc Code

ST329

14

104253

14

AS1035J080812

Purchased

No

100

Each

4.0000

1

10

TEE

Location

Loc Qty

Loc Code

MEZZ

4

112901

4

115055

4 SN 10/07/27

8 10/07/27

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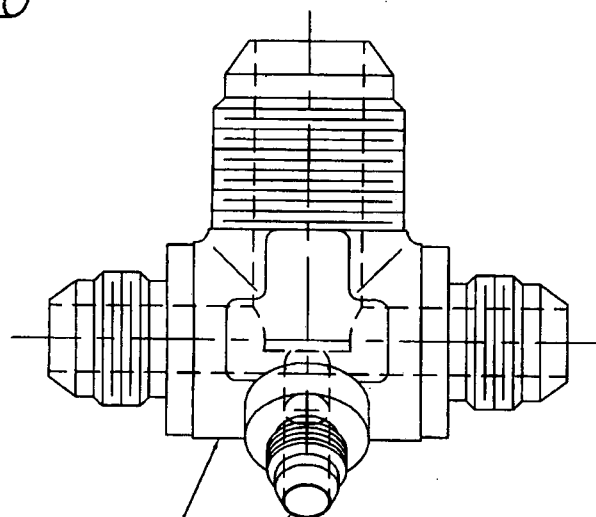
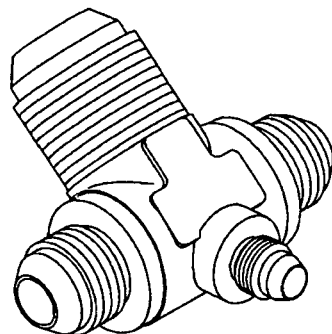
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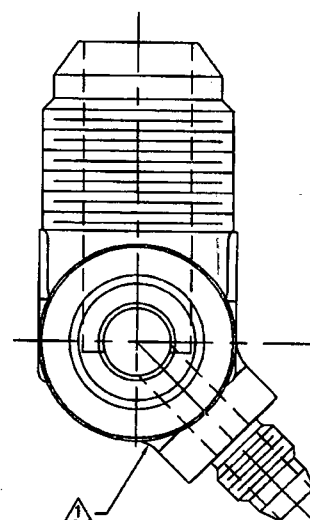
NOTE: Date & initial all entries



-003 REDUCER TEE

-005 UNION

-001 REDUCER TEE ASSY



SHOW COPY
REVISION
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK CAL
NO. 59810
BS10-6-11

△ PRESSURE TEST TO 3,000 PSI.

△ QQ-P-35 PASSIVATE FINISH AFTER WELD.

△ WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

NOTES:

				1	-005	UNION	MAKE FROM AN815-4J UNION			
				1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-12C			
					-001	REDUCER TEE ASSY				
				-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
NO. REQ'D PER ASSY					LIST OF MATERIAL					
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						CHECK D. MURPHY 5/24/02				
						STRESS				
						PROD. ENGR.				
				-001	2	41232-000-001		DWG. SIZE C	SCALE 2:1	
						HEAT TREAT				
						FINISH	△	Ern Aviation, Inc.		
								DWG. NO. 41232-200-004	REV. SHT 1 OF 2	IR

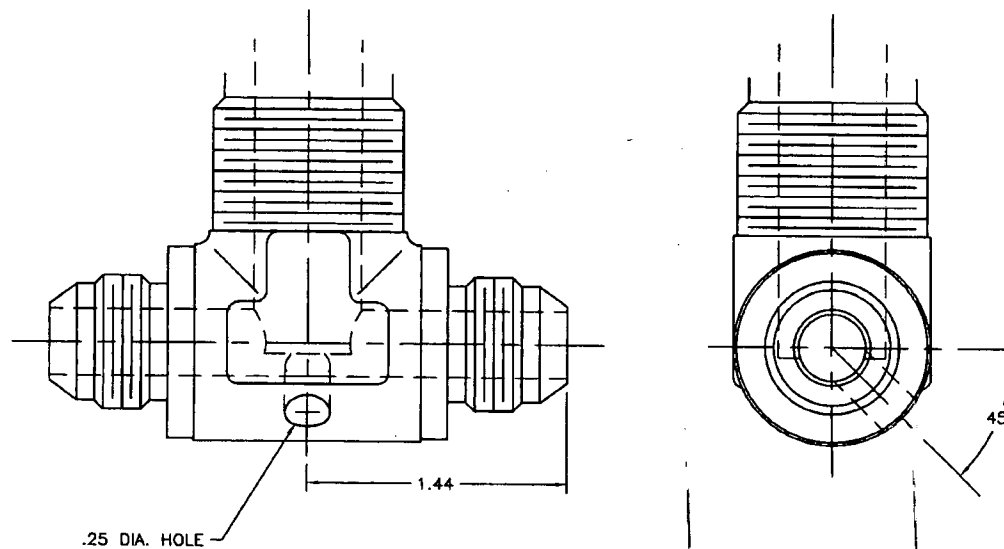
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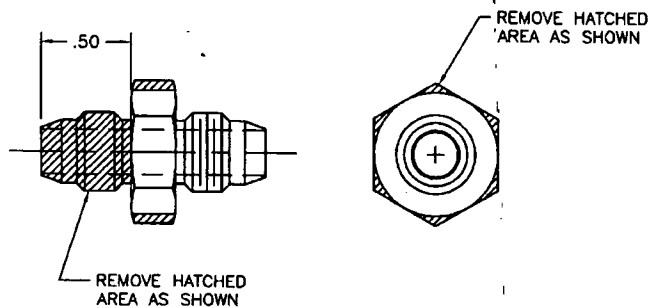
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-003 REDUCER TEE



-005 FITTING

W/O 59810

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Era Aviation, Inc.

TITLE

REDUCER TEE ASSY

SIZE

C

DRG. NO.

41232-200-004
SHT 2 OF 2

REV.

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W/O:		WORK ORDER CHANGES					
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